

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009948**Date Inspected:** 04-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jha and Xu Yumin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trail Assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) S. Manjunath. Math was present during the times noted above for observations relative to the work being performed.

Orthotropic Box Girder (OBG) Trial Assembly Area

Lift 1 (East)

This QA Inspector performed Ultrasonic Test along with Mr. Bert Madison, Gary Richmond to the Transverse Segment Weld for segment 1AE to 1AAE after repairing the weld at Bottom Panel (Weld number identified as OBE1A-003), Side Panel (Cross Beam weld number identified as OBE1A-002 and Bike Path Side weld number identified as OBE1A-004). Prepared a consolidated report for the all the inspectors involved and consolidated report submitted to Mr. John Kinsey for review.

Lift 2 East

This QA Inspector performed Ultrasonic Test along with Mr. Bert Madison to the Transverse Segment Weld for segment 2AE to 2BE at Side Panel, Cross Beam side weld no is identified as OBE2A-003. Prepared a consolidated report for the all the inspectors involved and noticed that 3(Three) indications were found and in which 1(one) indication was Class A reject +9 was recorded. Scanning was been performed between Datum (Y) distance between 0 to 4700mm and consolidated report submitted to Mr. John Kinsey for review.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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### Segment 1AE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Base material repair. The weld joint was been performed against B-WR7767 Rev.0. The welder is identified as 066413. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i. e., WPS-345-SMAW-4G(4F)-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

#### Summary of Conversations:

No relevant conversations.

#### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Math,Manjunath
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert
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QA Reviewer
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